

Work Order ID 94319

December-07-12 10:05:27 AM

94319

Page 1

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 12/07/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/21/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2650

F(DEO)

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG004

N/A

Work Order ID 94319

December-07-12 10:05:27 AM

94319

Page 2

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Start Date: 12/07/12 Start Qty: 1.00 ***1***

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M122130/M122324

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

BE 13-01-28

SAD 13-02-07

Work Order ID 94319

94319

Page 3

December-07-12 10:05:27 AM

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Start Date: 12/07/12 Start Qty: 1.00 ***1***

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

115

115

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS
15
9-89

13.2.8

J

120

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

②

SAD 13-02-01

125

125

QC

Quality Control

QC7-Inspect Chemical Conversion Coat

Memo

0.00

0.00

DAS
03
9-89

13-2-11

Work Order ID 94319

December-07-12 10:05:27 AM

94319

Page 4

Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 12/07/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/21/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

3-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cuttingStart Date: 12/27/12 Time: 2:00Finish Date: 12/27/12 Time: 1:00A/RSikaflex-291 7123944Sikaflex expiry date: 22/06/2013

SAA 13-02-11

SAD 13-02-11

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

1 0 13-02-13

DAS
18
8-83

Work Order ID 94319

94319

Page 5

December-07-12 10:05:27 AM

Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube
Start Date: 12/07/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/21/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002								
	2- Install nut plate as per dwg								
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
190 *190* HandFinish	Pressure Wash per QSI005 4.3	0.00							
Hand Finishing	Memo	0.00							
	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								

WELDED 19 SPACERS A/R M122130 BE 13-02-13
QC 13/02/14

QC 10 → 13-02-14

QC 5 → 13 02 14

(DAS 09)

(DAS 15 8-00)

1 16 13-2-19

Shy Feb 28
*943

94319

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 12/07/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/21/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

205

0.00

205

0.00

SprayPaint

Memo

Spray Painting

PRIME B 117319

SPRAY PAINT

DELFLEET BLUE B 121722

CLEAR DELFLEET B 118093

215

QC14- Inspect Spray Paint

0.00

215

0.00

QC

Memo

Quality Control

Work Order ID 94319***94319***

Page 7

December-07-12 10:05:27 AM

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

220

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RSikaflex-291 M124614Sikaflex expiry date: 13105

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/RSikaflex-291 M124614Sikaflex expiry date: 13105

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: M1237651 x 1316C/75

Work Order ID 94319

December-07-12 10:05:27 AM

94319

Page 8

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Stop ***NR2***

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			
250 *250* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-341 Location: _____ PPP Rev: _____	0.00 0.00				1			

Work Order ID 94319

94319

Page 9

December-07-12 10:05:27 AM

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Required Date: 12/21/12 Req'd Qty: 1.00 ***1***

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Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

MLS 13-02-28

mf

13-2-28

Picklist Print

December-07-12 10:05:24 AM

Page 1

Work Order ID: 94319

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 12/07/12

Required Date: 12/21/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440
rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf: DD IPP
Rev: L 12.11.22 now swage per ecn12-679 DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130 Insert		Purchased	No			220	Each	389.0000	54	54		13/02/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		389		M124080		54			
				119084		116							
				120671		89							
				120807		36							
				120837		8							
				121269		140							
AN960C10L washer	NAS1149C0332R	Purchased	No			220	Each	21.0000	54	54		13/01/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST245		21							
				107534		21							
AN960JD10L Washer	NAS1149D0332J	Purchased	No			220	Each	0.0000	2	2		13/02/25	
AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	29.0000		1		13/02/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		29							
				116289		8							
				119097		21		M122441					

Picklist Print

December-07-12 10:05:24 AM

Page 2

Work Order ID: 94319

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 12/07/12

Required Date: 12/21/12

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

Each

418.0000

Cherry Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
123780		
FP001	67	
122973	67	
ST327	351	
117849	5	
119017	188	
123265	158	

DC 13²/02/14

(2)

CR3212-4-03

Purchased

No

Each

1,608.0000

Cherry Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	204	
114859	204	
ST328	594	
123265	500	
123301	94	
ST331	810	
110139	2	
114859	0	
119017	808	

DC 13²/02/14

(2)

D2620

Manufactured

No

Each

8.0000

Skidtube, 206 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	8	
90433	2	
91130	4	
91131	2	

1

BE 13-01-28

December-07-12 10:05:25 AM

Shop Packet Print

Page 2

Picklist Print

December-07-12 10:05:25 AM

Page 3

Work Order ID: 94319

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 12/07/12

Required Date: 12/21/12

Start Qty: 1.00

Required Qty: 1.00

D2646
Aft Cap

Manufactured No

220 Each 132.0000

1 HL 1 13/02/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
90495	2	B81974
FP001	130	
62678	5	
68280	5	
70945	1	
71070	2	
73294	1	
73825	2	
79562	2	
81974	10	
85443	2	
85848	4	
90495	1	
91189	95	

D2647
Cap

Manufactured No

Each 115.0000

1 BE 13-01-28

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	115	
75482	2	
90496	8	
91190	105	

December-07-12 10:05:25 AM

Shop Packet Print

Page 3

Picklist Print

December-07-12 10:05:25 AM

Page 4

Work Order ID: 94319

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 12/07/12

Required Date: 12/21/12

Start Qty: 1.00

Required Qty: 1.00

D2651-1
Plug

Manufactured No

220 Each 372.0000

14 14 13/02/25

Location

Loc Qty

Loc Code

FP001

372

B96853

57869

1

x6

66445

10

69018

2

70827

2

77559

31

78124

5

78584

14

79234

4

81954

6

85456

3

89714

86

x8

91192

208

D2651-3
O-Ring

Manufactured No

220 Each 1,154.0000

14 14 13/02/25

Location

Loc Qty

Loc Code

FP001

1154

61962

12

73828

4

78126

138

90507

1000

x14

D2654-5
Web

Manufactured No

Each 2.0000

14 SAH 13-02-11

Location

Loc Qty

Loc Code

LG

2

87237

1

90252

1

B89994

①

December-07-12 10:05:25 AM

Shop Packet Print

Page 4

Picklist Print

December-07-12 10:05:25 AM

Page 5

Work Order ID: 94319

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 12/07/12

Required Date: 12/21/12

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Nut Plate Manufactured No Each 117.0000

Location	Loc Qty	Loc Code
ST014	117	
78016	4	
90499	23	
91162	90	

DC 13/02/14

D3535-11 Wearshoe Manufactured No 220 Each 7.0000

Location	Loc Qty	Loc Code
FP002	7	1393417
90207	7	

①

1 1

13/02/25

D3535-23 Wearshoe Manufactured No 220 Each 38.0000

Location	Loc Qty	Loc Code
FP002	38	
89963	12	
90518	13	
93181	13	

1 1

13/02/25

D3535-35 Wearshoe Manufactured No 220 Each 10.0000

Location	Loc Qty	Loc Code
FP002	10	1393799
67598	1	
70815	1	
79849	1	
86191	1	
92343	6	

1 1

13/02/25

Picklist Print

December-07-12 10:05:26 AM

Page 6

Work Order ID: 94319

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 12/07/12

Required Date: 12/21/12

Start Qty: 1.00

Required Qty: 1.00

D3536-11
Gasket

Manufactured No

220 Each 22.0000

1 11 1 13/02/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	22	
46649	1	
46715	4	
65574	1	
80006	1	
87932	15	

x1

D3536-23
Gasket

Manufactured No

220 Each 23.0000

1 11 1 13/02/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
85295	2	
FP001	21	
74510	1	
83377	1	
89928	17	
93882	2	

x1

D3536-35
Gasket

Manufactured No

220 Each 38.0000

1 11 1 13/02/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
89650	2	
FP001	36	
82065	2	
90844	10	
93911	24	

~~1355686~~

B93911

x1

Picklist Print

December-07-12 10:05:26 AM

Page 7

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Parent Item Name: Replacement Skidtube

Start Date: 12/07/12

Required Date: 12/21/12

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No
Wearpad

220 Each 38.0000

6 ll 6 13/02/25

Location

Loc Qty

Loc Code

FP001

38

B94395

x6

83254

1

83255

3

87697

1

88562

9

91668

24

D3537-3 Manufactured No
Wearpad

220 Each 15.0000

1 ll 1 13/02/25

Location

Loc Qty

Loc Code

FG

8

86237

8

B93366

x1

FP001

7

78836

1

90147

6

D4720-1 NA D2649 Manufactured No
Spacer

150 Each 0.0000

19 ll 19 BE13/02/13
B93662 x 19

MS27039-1-08

Purchased No

Each 814.0000

ll 2 13/02/25

Screw

Location

Loc Qty

Loc Code

FP001

30

122452

30

GA

69

117423

69

ST305

715

119075

1

120308

44

121011

43

121243

500

121708

13

123265

114

y2

December-07-12 10:05:26 AM

Shop Packet Print

Page 7

Picklist Print

December-07-12 10:05:26 AM

Page 8

Work Order ID: 94319

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Start Date: 12/07/12

Required Date: 12/21/12

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

220

Each

161.0000

1

1

Screw

Location

Loc Qty

Loc Code

FP001

11

119075

11

ST307

150

123355

150

MS27039C1-08

Purchased

No

Each

814.0000

SCREW

Location

Loc Qty

Loc Code

FP001

294

122141

294

ST308

520

116022

1

116373

3

118077

14

119309

2

123352

500

X1

54

X54

13/02/25

13/02/25

December-07-12 10:05:26 AM

Shop Packet Print

Page 8

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

094319

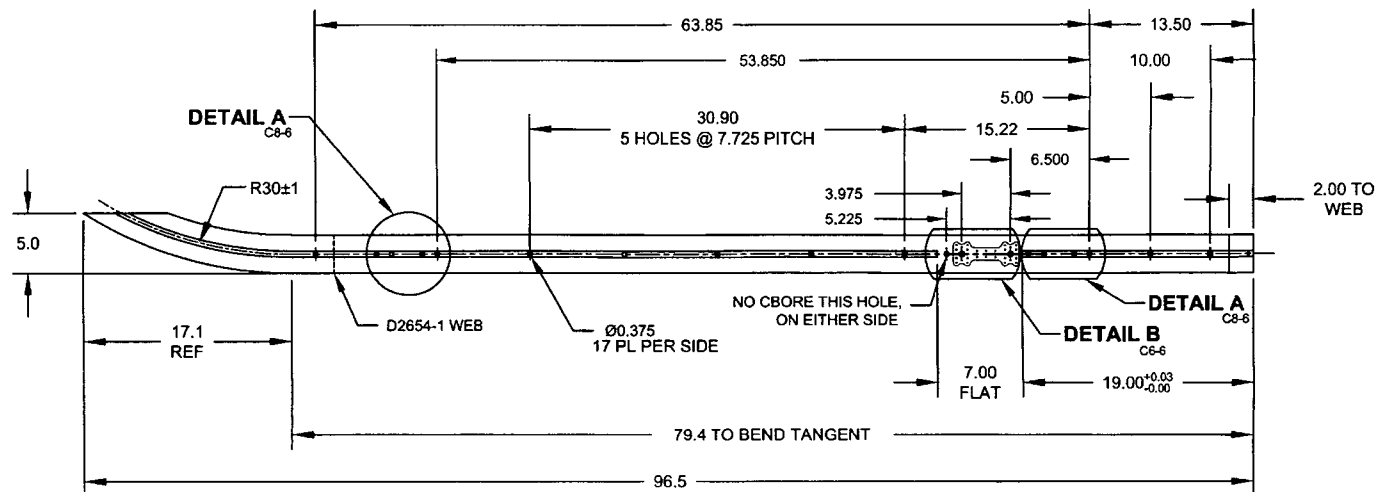
DEO ATTACHED

RELEASED
08-07-23-17

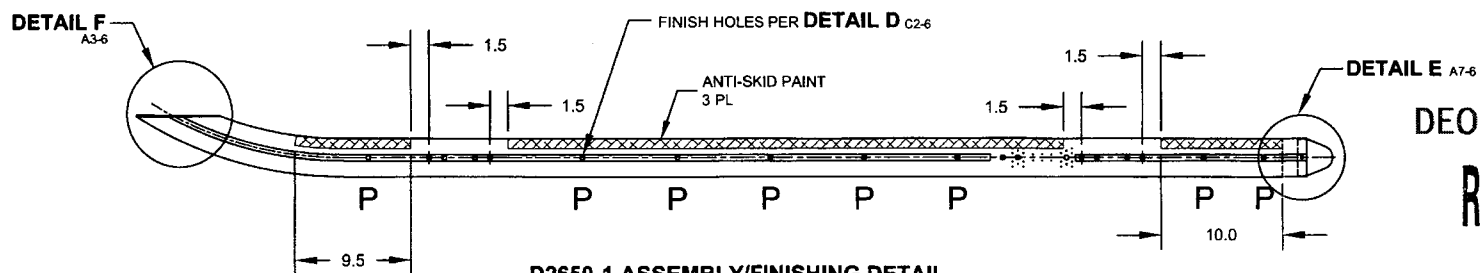
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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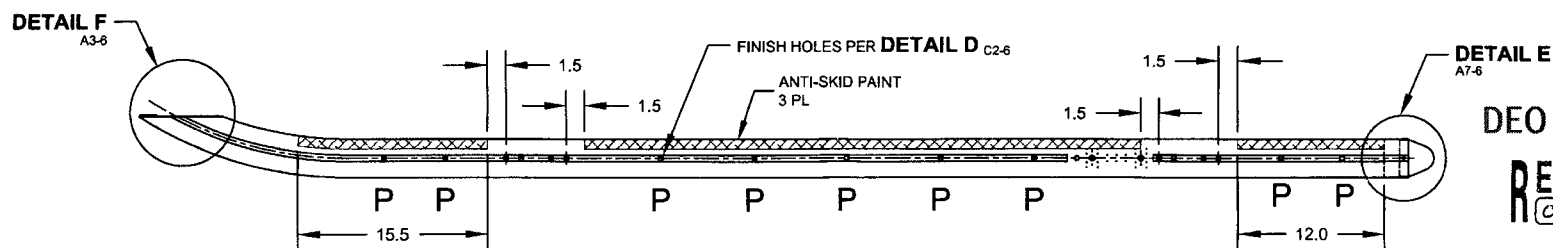
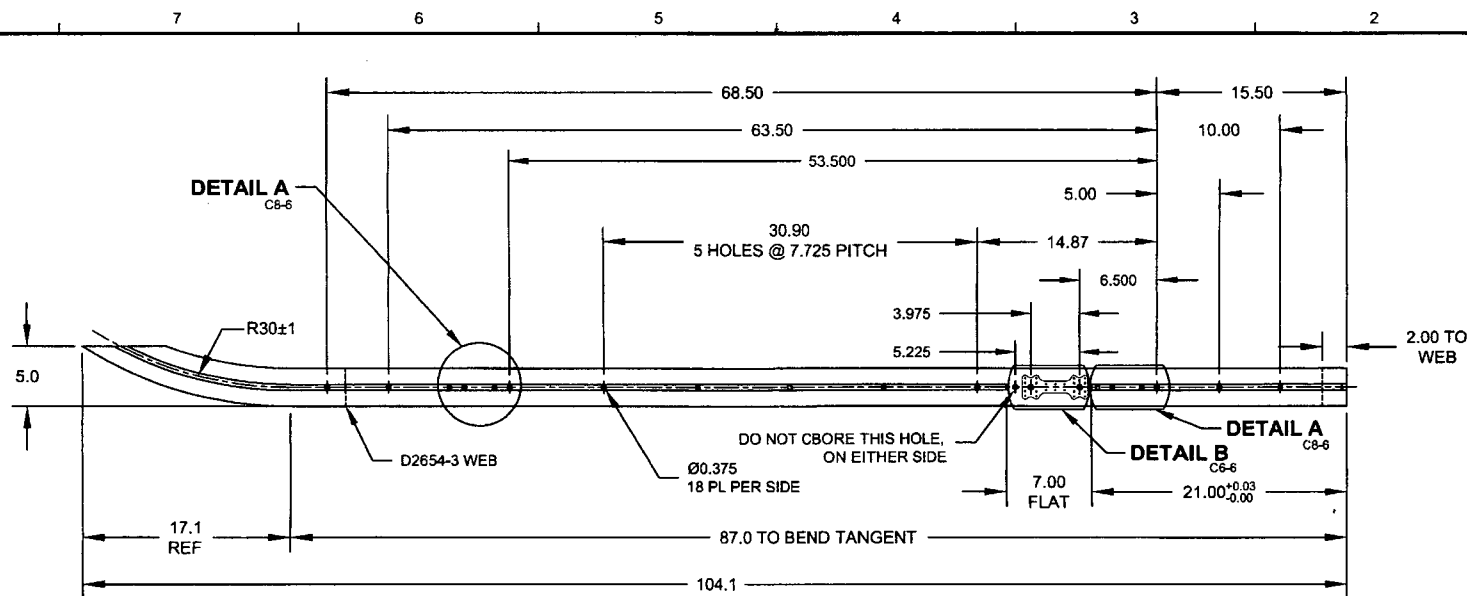
D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

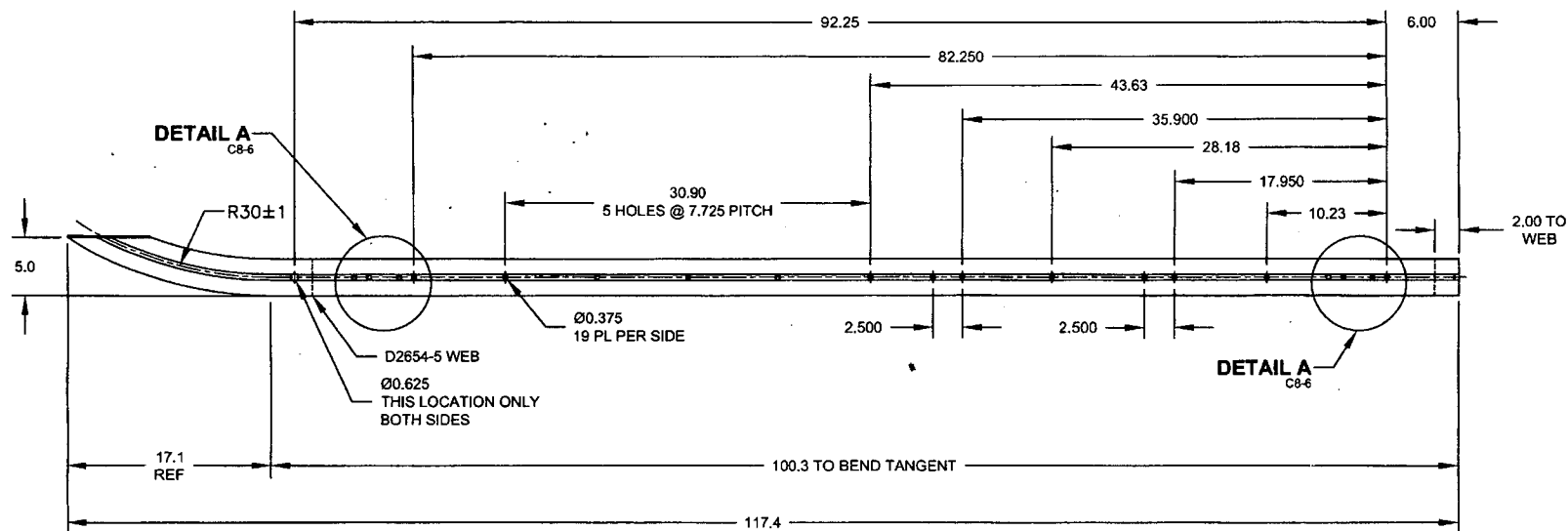
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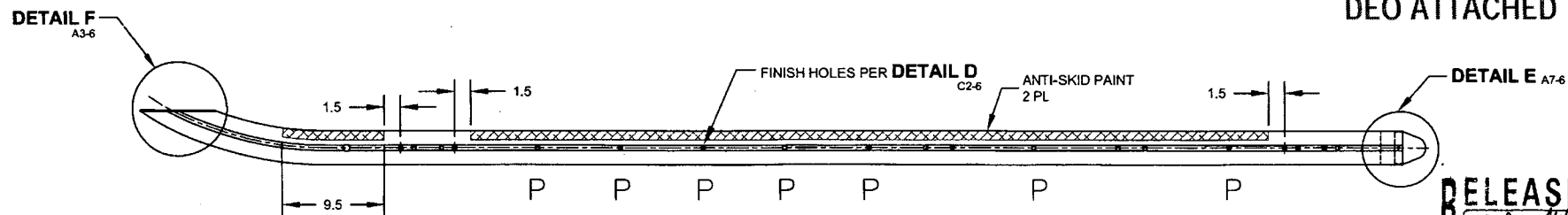


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D2650-5 BENDING/DRILLING DETAIL

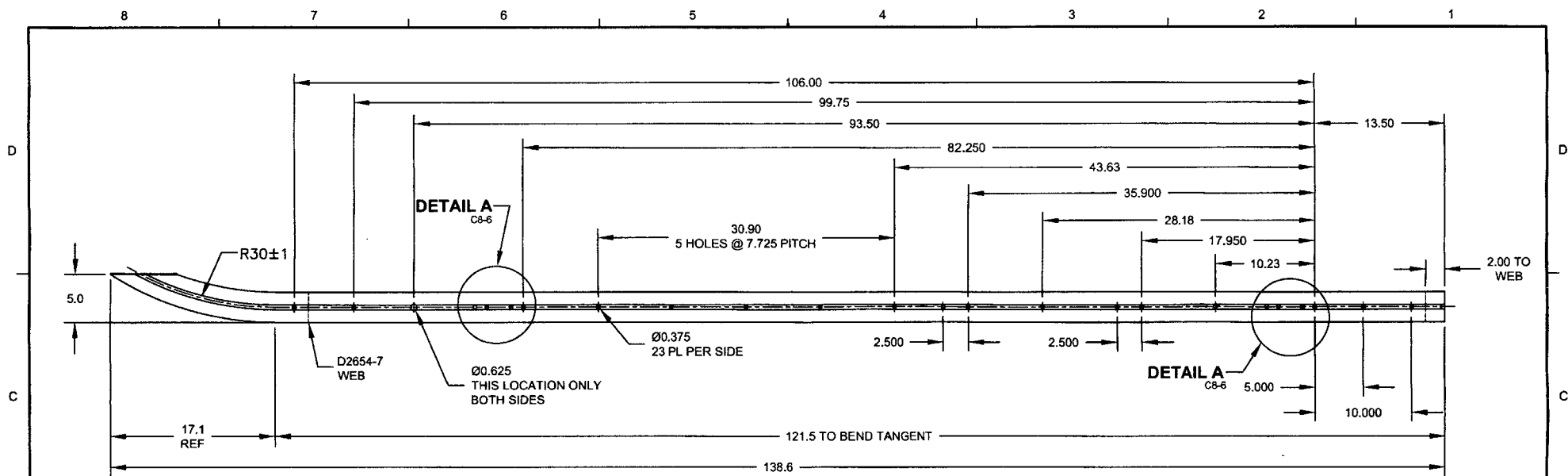


D2650-5 ASSEMBLY/FINISHING DETAIL

DEO ATTACHED

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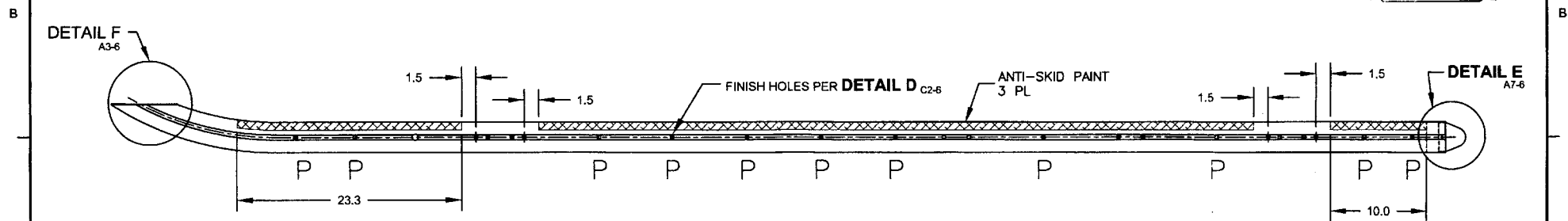
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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D2650-7 BENDING/DRILL DETAIL

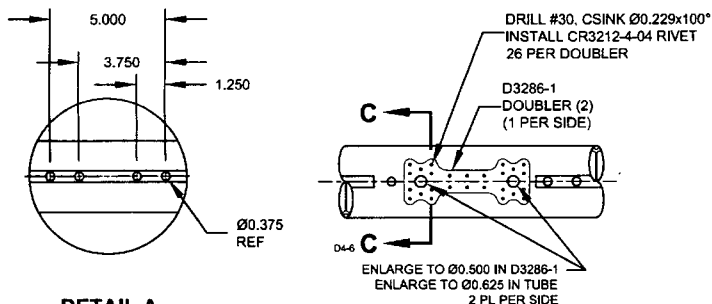
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08 07 22

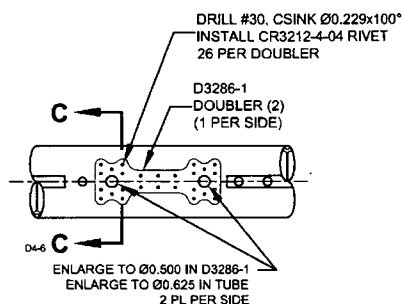


D2650-7 ASSEMBLY/FINISHING DETAIL

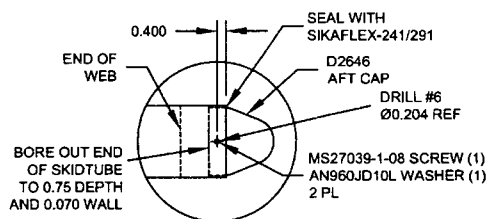
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MFG. APPR.		D2650	SHEET 5 OF 6
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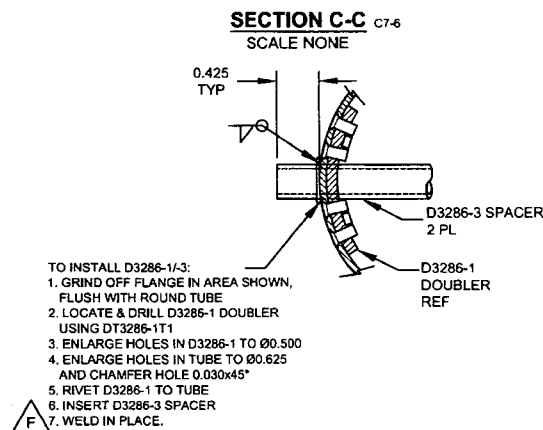
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5



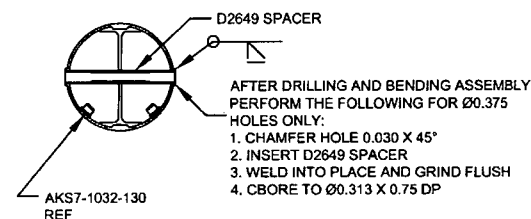
DETAIL B
SCALE 2X
C3-2
C3-3



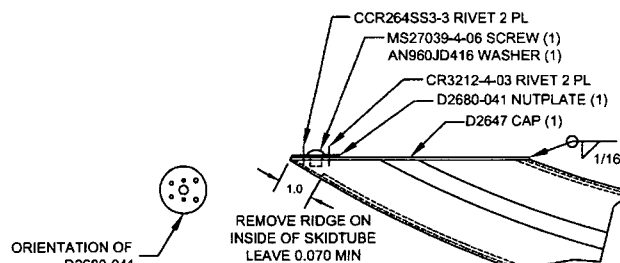
DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



F



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5







DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED

DEO ATTACHED

DESIGN	DS	DART AEROSPACE USA, INC	
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MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN [Signature]	CHECKED A.P.	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

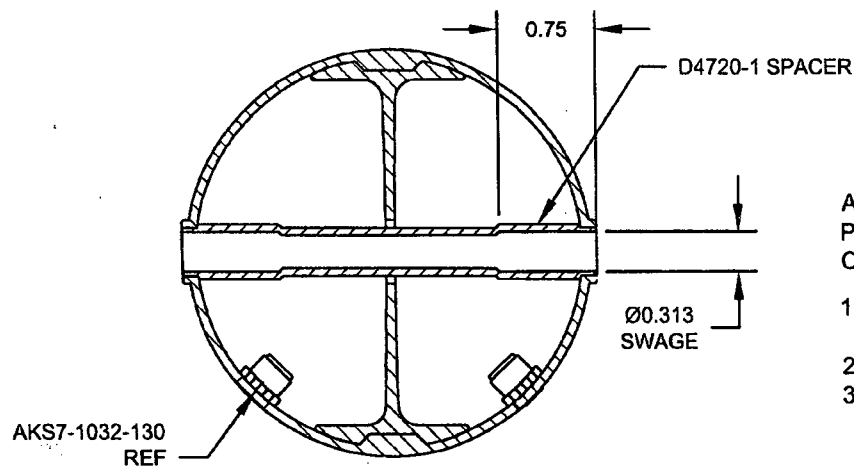
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

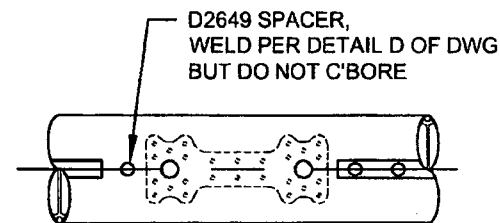
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL G

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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NO. 313

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: 87449
Part #: D206-642-441
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Incomplete Penetration:
Incomplete Fusion:
Cracks:
Overlap (cold lap)
Undercut:
Pin holes:
Porosity (surface):
Coloration:
Burn through:

pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>

Qualifier DAS
09
Date of Test Coupon 13-02-04
Welder Barclay Elliott
Date of Test Coupon 13-02-04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld